

Work Order ID 57813

Thursday, April 15, 2010 3:57:55 PM



SHIP Friday

Page 1

Item ID: D119-696-011

Accept



Setup Start



Revision ID:

Item Name: Single Cargo Mirror Installation

Stop



Start Date: 4/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/16/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-4-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D119-696-011

CHG004

8/10/16

HJ for BG 10/04/16

110

Pick list

0.00



Packaging

Packaging

Memo

0.00

Packaging

8/10/16

10/14/16

①

(H)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/16

(H)

DART			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D119-696-011	CHG	CHG003
DESC.	Single Cargo Mirror	STC	SR01043SE
LOT	B18131	STC	
MODEL	Agusta A119	STC	
MADE IN CANADA			

TEL: 1-613-632-3336
FAX: 1-613-632-4443

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Setup Start



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Stop



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Start Date: 4/15/2010 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-696-011

Location:

PPP Rev: _____

NEW E

Rec'd 4/16 (1)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/4/16 JF

MF

10-4-16

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Picklist Print

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Work Order ID: 57813



Parent Item: D119-696-011



Parent Item Name: Single Cargo Mirror Installation

Start Date: 4/15/2010

Required Date: 4/16/2010

Comments: IPP Rev:A new issue DD 10.04.15 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D119-696-041 Single Cargo Mirror Assy		Manufactured	No			110	Each	4.0000	1.0000 			

Warehouse
Location

Loc Qty

Loc Code

Premier

Mezz

18131

4

4

110

Each

13.0000

1.0000

18131

D2053



Mounting Bracket

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST005

47595

13

13

110

Each

25.0000

1.0000

47595

D2067



Connector

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST006

54698

25

25

54698

10/4/16 ①

Dart Aerospace Ltd

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Parent Item: D119-696-011

Parent Item Name: Single Cargo Mirror Installation

Comments: IPP Rev:A new issue DD 10.04.15 verified by:EC


Start Date: 4/15/2010

Required Date: 4/16/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2071  Cable Assembly		Manufactured	No			110	Each	10.0000	1.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location


Main Warehouse

ST222

10

57578

10

D3083-1  Placard		Manufactured	No			110	Each	10.0000	1.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location


Main Warehouse

ST036

10

47686

10

AN526-1032R9  Screw		Purchased	No			110	Each	207.0000	4.0000			
---	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST328

207

113928

7

114382

200

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Shop Packet Print

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Parent Item: D119-696-011

Parent Item Name: Single Cargo Mirror Installation

Comments: IPP Rev:A new issue DD 10.04.15 verified by:EC

Start Date: 4/15/2010

Required Date: 4/16/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10-1001149 03630 Washer		Purchased	No			110	Each	0.0000	4.0000			
MS21919-DG5 Clamp		Purchased	No			110	Each	40.0000	2.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST306

40

114348

40

MS27039-1-09

Purchased

No

110

Each

479.0000

4.0000

Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST291

479

111650

444

18057

35

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Comments: IPP Rev:A new issue DD 10.04.15 verified by:EC

Start Date: 4/15/2010

Required Date: 4/16/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS35489-9  Grommet		Purchased	No			110	Each	96.0000	1.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST296

96

107376

16

109371

80

ALS-1032-130

Purchased

No

110

Each

0.0000

2.0000

INSERT

107376

m113238 R10/4/16 ①

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25.2 CARGO MIRROR REMOVAL

1. Loosen MS21042-3 nut and remove D2071 control cable from D2067 connector.
2. Remove (4) MS27039-1-09 screws and remove D3072-1/-2 brackets. Re-install MS27039-1-08 screws.
3. Remove (2) AN526-1032R9 screws and (2) MS21919DG5 clamps.
4. Remove (2) AN526-1032R9 screws, the D2053 bracket and the D2071 cable assembly. Re-install AN526-1032R9 screws to plug inserts.
5. Seal MS35489-9 grommet hole with PRC / RTV / Proseal 890 / Sikaflex-241 / Sikaflex-291 / MIL-C-8802 Class B2 sealant.

25.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-696-011	2.2 lb	7.0 in	15.4 in-lb	22.0 in	48.4 in-lb
Cargo Mirror Installation	1.00 kg	0.28 m	0.28 m-kg	0.87 m	0.87 m-kg
D119-696-013	3.0 lb	1.0 in	3.0 in-lb	22.0 in	66.0 in-lb
Cargo Mirror Installation	1.36 kg	0.04 m	0.05 m-kg	0.87 m	1.18 m-kg

25.4 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Part Number	Description
X				D119-696-011	SINGLE CARGO MIRROR INSTALLATION
	X			D119-696-013	DUAL CARGO MIRROR INSTALLATION
1		X		D119-696-041	SINGLE CARGO MIRROR ASSEMBLY
	1		X	D119-696-043	DUAL CARGO MIRROR ASSEMBLY
		1	2	D2011-101	MIRROR ASSEMBLY
1	1			D2053	BRACKET
		2	2	D2054	BUSHING
		2	2	D2055	CLAMP
		1	1	D2056	BELL CRANK
		1		D2057	PLUG
1	1			D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	2	*D3014-1	LOCKNUT
		1	1	D3072-1	BRACKET
		1	1	D3072-2	BRACKET
		1		D3074-1	ARM
			1	D3074-3	ARM
1	1			D3083-1	PLACARD
4	4			AN526-1032R9	SCREW
4	4	6	6	AN960JD10	WASHER
		1	2	*AN960JD416L	WASHER
		3	3	MS21042L3	NUT (or MS21042-3)
2	2			MS21919DG5	CLAMP
4	4			MS27039-1-09	SCREW
		3	3	MS27039-1-18	SCREW
4	4			MS35489-9	GROMMET
2	2			AKS7-1032-130	INSERT (or ALS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or AELS-032-130)

*INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

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